

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000505**Date Inspected:** 30-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Arbin Huang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	77m Mock-Up		

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 Skin Plate-A Stiffener Plate-2 Grinding being performed on the back gouged area of the root pass of stiffener 2, side A (Root weld towards stiffener plate #4). Areas of concern were marked for rework. The QA present was Ken Zhang. Grinding did continue until all areas of concern were eliminated. Welding began when preheat had been established (134C to 157C). The welder was Zhou Shijie using wire Supercored 71H/ 1.4mm diameter with a travel speed of 294.7 mm/min. The amps were checked at 285 and the volts at 31.9.

Item-2 Skin Plate-D Stiffener Plate-1 Requires the cover pass on both sides of the stiffener plate. Stiffener plate 2 root pass and the welder operator is Liu Xie #066236 travel speed was 315.1 mm/min. & Amps/Volts stated from the isle side back was 304-A/284-A & 31-V/30-V. The welding wire was Supercored 71H & 1.4mm/dia. Welding had not been completed prior to leaving inspection area. The QA was Zhang Jia di, QC Zhu Zhong and the CWI was Arbin Huang.

Item-3 Sub-Assembly SA95-1 Joint number 73 is being preheated for the installation of the root welding Material is 485-W.

Item-4 Sub-Assembly SA104 weld joint 73. Preheat was being performed with the temperature range recorded at 86C to 143C within the heat affected zone and the weld areas.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
